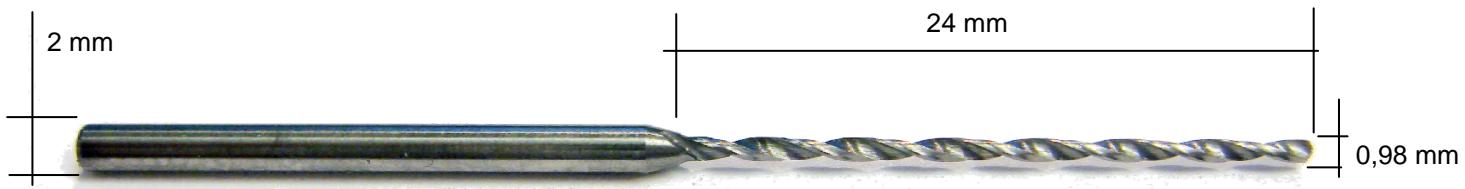


## MicroDrill Ø0,98mm Z2

A05-010



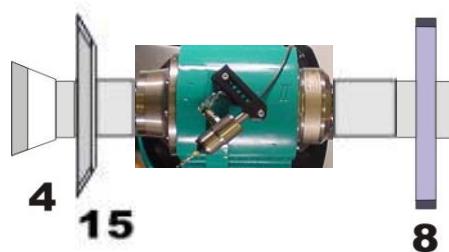
### 1. Cycletime for Production

Tool specifications						
Diameter 0,98 mm, Z 2, Length of cutting edge 24 mm, Helix angle 30°						
Material CARBIDE						
Operations						
Feed [mm/Min]	2000	4000	90	4000	90	90
Power [kW]		1	2	1	1	1
Cutting feed [m/s]		18	32	24	24	24
Used wheels						
Grinding time [s]	34	12	16	37	41	41
Total cycle time	3 Min 0					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

15 Ø125 1V1 D46  
8 Ø125 1A1 D46  
4 Ø75 11V9 D46



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3, DXQ

responsible engineer:

[www.schneeberger.ch](http://www.schneeberger.ch)

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